

ABSTRACT

A method for introducing and compacting molding sand S in a mold space defined by a pattern plate (10a), a lower auxiliary frame (16b), a flask (18), a filling frame (20), and multi-segmented squeeze feet (36a). First, the molding sand S is introduced into the mold space. The squeeze feet (36a) are then lowered to apply a first squeeze to the mold sand S in the mold space under a condition wherein at least the lower frame (16a) cannot be lowered. The squeeze feet (36a) are then lowered to apply a second squeeze to the mold sand S in the mold space under a condition wherein the lower frame (16a), the flask (18), and the filling frame (20) can be lowered.